Work Order ID 67925

Tuesday, April 05, 2011 9:58:22 AM

Item ID: D3685-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: BIPOD MOUNT ASSEMBLY (1)

Start Date: 4/4/2011 **Start Qty:** ~~2.00~~ **Cust Item ID:**

Required Date: 4/8/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3685	Rev D								
100	Pick Kit	0.00				(1)			
Packaging	**Memo**	0.00							
Packaging									
110	Small Fab	0.00				(1)			
Small Fab	**Memo**	0.00							
Small Fab									

SB 11/07/04

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivelent on thread and assemble as per dwg D3685

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685
***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3685

SB 11/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: 77	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/06

11/7/06

11-07-06

Dart Aerospace Ltd

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Picklist Print

Tuesday, April 05, 2011 9:58:28 AM

Work Order ID: 67925

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 4/4/2011 **Required Date:** 4/8/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments:
IPP Rev:A new issue 08-02-12 DD verified by:LL
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	41.0000	4	8	SB	11/07/04	②
Bolts													
				Location			**Loc Qty**		**Loc Code**				
				ST351			41		M 117794	4			
					116924		41		M 116924	2			
D3684-047		Manufactured	No			110	Each	2.0000	1	2	SB	11/07/04	②
FWD LEG ASS'Y													
				Location			**Loc Qty**		**Loc Code**				
				GA			2		B 68386	1			
					62982		2						
D3684-049		Manufactured	No			110	Each	0.0000	1	2			
AFT LEG ASS'Y									B 67927	1	SB	11/07/04	②
D3687-3		Manufactured	No			110	Each	7.0000	1	2	SB	11/07/04	②
MOUNT													
				Location			**Loc Qty**		**Loc Code**				
				GA			7						
					61890		3			1			
					61964		4						

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Tuesday, April 05, 2011 9:58:28 AM

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Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 4/4/2011 **Required Date:** 4/8/2011

Start Qty: 2.00 **Required Qty:** 2.00

D3692-1 SPACER	Manufactured	No	110	Each	225.0000	8	16	SB 11/07/04

Location	Loc Qty	Loc Code	
ST075	225		
51467	225		8

MS21043-3 Nut	Purchased	No	110	Each	1,072.000	4	8	SB 11/07/04

Location	Loc Qty	Loc Code	
FG	80		
103691	80		
FP-B	16		
112314	16		
ST301	976		
112314	976		34

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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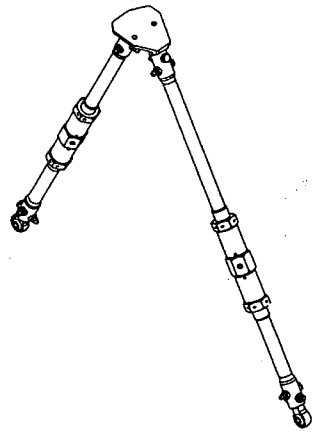
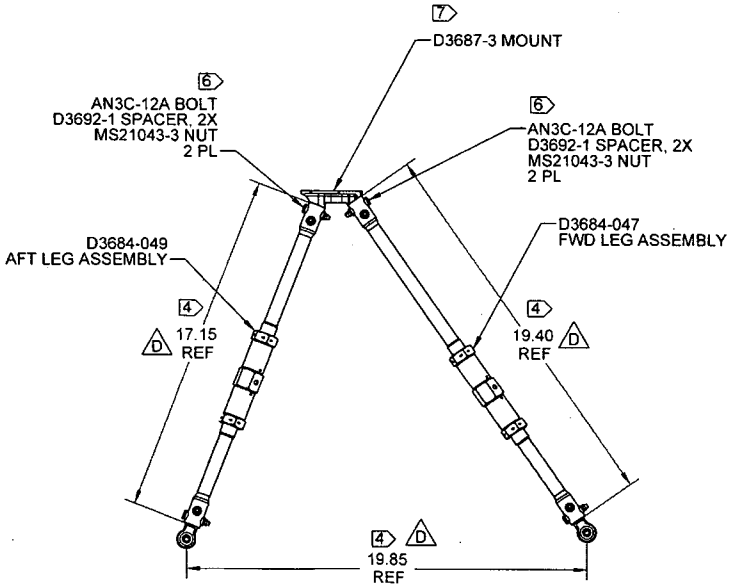
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT





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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47925

RELEASED
2010-03-15

D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED
3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
5) WEIGHT: 6.6 lbs
6) TORQUE FASTENERS T0 20-25 in-lbs
7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

REV.	DESCRIPTION	BY	DATE
D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22

DESIGN	RF
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.03.03

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3685 REV. D
SHEET 1 OF 1
TITLE BIPOD MOUNT ASSEMBLY
SCALE NTS

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Dart Aerospace Ltd

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